



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5500-1**Job Sheet 196673****Part No:** D5500-1**Job Qty:** 3 pcs**Part Name:** Body, Upper Cutter**Part Weight:** 0 lbs**Status:** Scheduled**Priority:** Medium**Job Created:** 6/18/19**Job Tracking No:****Due Date:** 7/16/19**Created By:** Patrick Lussier**Type:** Stock**Description:**

Note: D5500 REV:A IPP REV:A 17.11.13 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.14 AS PER DWG REV:A8
DD VERF:JFS

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Purchasing	3 pcs		7/16/19	0.00	0.00	Purchasing - 1		
							Purchasing - 2		
							Purchasing - 3		
96	Packaging 2-1 - Receive - B4B	3 pcs		7/16/19	0.00	0.00	Packaging 2 - 1 - B4B		
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		
							Packaging 2 - 21 - B4B		
							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
							Packaging 2 - 24 - B4B		
							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		

See attached

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				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
97	QC 6	3 pcs	7/16/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
140	Outsource - 4 - Anodize	3 pcs	7/16/19		ATG001-VC 8
150	Packaging 2-2 - Receive - B4B	3 pcs	7/16/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
155	QC 6	3 pcs	7/16/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3

See affected

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 6 - 81	
160	Conventional Mill - 1 - B4B	3 pcs	7/16/19	0.00 0.00	Conventional Mill - 1 - B4B	11/19/17/26
					Conventional Mill - 2 - B4B	
165	QC 5	3 pcs	7/16/19	0.00 0.00	QC 5 - 10	JUL 26 2019 DAS 81 9-89
170	Handfinish - 1-1 Chemical-B4B	3 pcs	7/16/19	0.00 0.00	Handfinish - 1 - 1 - B4B	JUL 26 2019
175	QC 7	3 pcs	7/16/19	0.00 0.00	QC 7 - 10	JUL 26 2019
180	Packaging 3-1 - Stock - B4B	3 pcs	7/16/19	0.00 0.00	Packaging 3 - 1 - B4B	Bn: CCK 129
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
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					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	3 pcs	7/16/19	0.00 0.00	QC 21 - SA - 21 →	Bn: CCK 129 JUL 26 2019 DAS 70 9-89
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 95 - ISSUE P/O TO WEJAY:

MACHINE D5500-1 AS PER DWG C OF C IS REQUIRED

Descriptions: **96** - (Receive & Inspect for Damage & Mat'l Certs)
97 - (QC6- All purchased or subcontracted products)
140 - Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required
150 - (Receive & Inspect for Damage & Mat'l Certs)
155 - QC6- All purchased or subcontracted products
160 - AS PER VIEW B-B, REAM HOLES TO FINAL SIZE AFTER FINISHING AND DEBURR (see note 9)
165 - QC5- Inspect part completeness to step on W/O
170 - TOUCH UP BARE METAL WITH ELECTRICALLY CONDUCTIVE CHEMICAL FILM MATERIAL (ALODINE 600) PER MIL-DTL-5541
175 - QC7-Inspect Chemical Conversion Coat
180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D5500-1P	Body, Upper Cutter	3 pcs (1 ea)	95-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
95-Purchasing	D5500-1P	3	0	0

Part Specifications

Specifications could not be found.

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K6A 1K7
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D5500-1
Job Sheet 196673



Part No: D5500-1

Job Qty: 3 pcs

Part Name: Body, Upper Cutter



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/18/19

Job Tracking No:

Due Date: 7/16/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: D5500 REV.A8 IPP REV:A 17.11.13 NEW ISSUE DD VERF:JFS IPP REV:B 17.11.14 AS PER DWG REV.A8 DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
95	Purchasing	3 pcs	7/16/19		0.00	0.00	Purchasing - 1		JUL 11 2019
							Purchasing - 2		
							Purchasing - 3		
96	Packaging 2-1 - Receive - B4B	3 pcs	7/16/19		0.00	0.00	Packaging 2 - 1 - B4B		JUL 11 2019
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B		
							Packaging 2 - 8 - B4B		
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
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							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
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							Packaging 2 - 22 - B4B		
							Packaging 2 - 23 - B4B		
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							Packaging 2 - 25 - B4B		
							Packaging 2 - 26 - B4B		
							Packaging 2 - 27 - B4B		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S197495



Part: D5500-1

Job No: 196673

Serial No/Batch: S197495

Revision: A8

Inspector:

Exp Date:

Instructions:

Date: 07/11/19

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					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
97	QC 6	3 pcs	7/16/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	61
					QC 6 - 40	9-89
140	Outsource - 4 - Anodize	3 pcs	7/16/19		ATG001-VC	8 2019-07-15
150	Packaging 2-2 - Receive - B4B	3 pcs	7/16/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
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					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP JUL 19 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
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					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
155	QC 6	3 pcs	7/16/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	

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					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS
					QC 5 - 50	81
					QC 5 - 30	9-89
					QC 5 - 40	JUL 22 2019
180	Packaging 3-1 - Stock - B4B	3 pcs	7/16/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
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					Packaging 3 - 10 - B4B	
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					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	3 pcs	7/16/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op **95** - ISSUE P/O TO WEJAY: H8043770 MACHINE D5500-1 AS PER DWG C OF C IS REQUIRED
 Descriptions: **96** - (Receive & Inspect for Damage & Mat'l Certs)
97 - (QC6- All purchased or subcontracted products)
140 - Issue P/O to ATG: 44008 HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2
 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is
 required
150 - (Receive & Inspect for Damage & Mat'l Certs)
155 - (QC5- Inspect part completeness to step on W/O)
180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND
 REV***
190 - (QC21- Final Inspection - Work Order Release)

x 3 plus 10 June 2019

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
D5500-1P	Body, Upper Cutter	3 pcs (1 ea)	95-Purchasing	5197494
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
95-Purchasing	D5500-1P	3	0	0
Part Specifications				
Specifications could not be found.				

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043778



Supplier: WEJ001-VC
Wejay Machine Products Co. Ltd
600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Phone: 613-384-1662
Fax: 613-384-2997

PO No: POHB043778

PO Date: 6/18/19

Due Date: 7/16/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196673	D5500-1P			Body, Upper Cutter As per Dwg D5500 Rev. A	Firmed	-	7/16/19	3 Ea	0 Ea	3 Ea	\$2,436.00/Ea	\$7,308.00
2	196674	D5501-1P			Body, Lower Cutter, Long As per Dwg D5501 Rev. A	Firmed	-	7/16/19	2 Ea	0 Ea	2 Ea	\$3,144.00/Ea	\$6,288.00
3	196675	D5505-1P			Base, Upper Cutter : Various STC's As Per Dwg D5505-1 Rev. A	Firmed	-	7/16/19	3 Ea	0 Ea	3 Ea	\$1,120.00/Ea	\$3,360.00
4	196676	D5506-3P			Base, Lower Cutter, Long As Per Dwg 5506 Rev. A	Firmed	-	7/16/19	2 Ea	0 Ea	2 Ea	\$1,447.00/Ea	\$2,894.00

Grand Total: \$19,850.00



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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043778



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in blue ink, likely belonging to Patrick Lussier, is written over the signature line.

Plex 6/18/19 3:57 PM dart.lussier.patrick

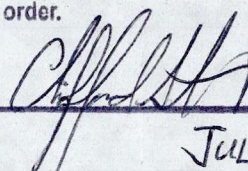


Packing Slip 39579

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
TEL: 613-384-1662 FAX: 613-384-2997
www.wejay.com

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K7

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Dart Aerospace
1270 Aberdeen Street
Hawkesbury ON K6A 1K

INVOICE DATE		YOUR ORDER NO. POHB043778		DATE ORDERED 06/18/19		SHIPPED VIA Best way	
CUSTOMER CODE DART		PROV. LIC. NO.		Extra ☐ Exempt ☐		TERMS	
QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION			UNIT PRICE	AMOUNT
3	0	3	Body, upper cutter as per drawing D5500, Rev. A Part No. D5500-1P				DAS 61 9-89
2	0	2	Body, lower cutter, long as per drawing D5501, Rev. A Part No. D5501-1P				
3	0	3	Base, upper cutter, various STC as per drawing D5505-1, Rev. A Part No. D5505-1P				
2	0	2	Base, lower cutter as per drawing D5506-3, Rev. A Part No. D5506-3P				
Required by: July 16, 2019 RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor  WMP 03 July 10/19 H.S.T.							
ORDER: COMPLETE ☐ PARTIAL ☐						TOTAL	

RECEIVED
JUL 11 2019
DART AEROSPACE LTD.

RECEIVED BY _____
1.5% PER MONTH (18% PER ANNUM)
CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
PRIOR AUTHORIZATION

Journal of Management Education

11. 10. 1982 - 19. 10. 1982

1. The first part of the text discusses the importance of maintaining accurate records of all transactions, including sales, purchases, and expenses. It emphasizes that proper record-keeping is essential for determining the correct amount of tax liability and for defending against potential audits.

THE UNIVERSITY OF CHICAGO

REVIEWS



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: DART Aerospace

DATE: July 10, 2019

P.O.# POHB043778 item 1

WEJAY JOB# 39579

I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below.

PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D5500-1P 'Base, Upper Cutter' JOB # 196673	3	Machined complete per drawing req'ts.	D5500 / rev. A DAS 61 9-89

Note: 1) Material: . Material Test Certs. attached

- for part s/n 39579-1-001 and 39579-1-002, - ref. 'Constellium' Lot# 9440809 (Wejay TN# 35073-1).

- for part s/n 39579-1-004, DART supplied material - ref. 'Aleris' Lot# 1750027398 (DART s/n S010035).

2) 1st Article Inspection / Test Report attached.

Records of Inspection/Test will be retained for 5 years minimum.

Sincerely,



Clifford Smith

Authorized Q.A. Signatory



CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

SHIP TO
THYSSENKRUPP CA
2821 LANGSTAFF ROAD
CONCORD ON
L4K 5C6
CA

SOLD TO
COPPER & BRASS SALES
PO BOX 5116
SOUTHFIELD MI
48086
US

COPPER&BR		110730252	4075	INCLUSION	Serial:20190201-0110730252	Pg 1of2
CUSTOMER PURCHASE ORDER NO. & ITEM 5400424185-R01				Constellium ORDER NO. 264541		CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunbarger - Laboratory Manager
ALLOY 7075	CLAD	TEMPER T651	GAUGE 2.03000 in 51.56 mm	WIDTH 60.50000 in 1,537 mm	LENGTH 144.50000 in 3,670 mm	
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH						
CUSTOMER SPECIFICATION AMS QQ-A-250/12A						
PART NUMBER ALFLR00999		B/L NUMBER 112678		DATE SHIPPED 02/01/2019		
WT. SHIPPED 5580.000 LB		NO. OF PIECES 000003		GOVT. CONTRACT NO.		

ALL LOTS ON THIS CERTIFICATION ALSO CONFORM TO THE FOLLOWING REQUIREMENTS:

AMS 4045L
ASTM B209-14

Load Details

Package	Net Lbs	Kg	Lot	Piece	Serial	Parent Lot
1001965365	1,860.000	843.681	9440809	01		
1001965365	1,860.000	843.681	9440809	02		
1001965366	1,860.000	843.681	9440809	03		

Lot: 9440809 (See test results below)

Tensile - Room Temperature (US)

		Ultimate (KSI)		Yield (KSI)		Elongation (%)		Report
Direction	Tests	Min	Max	Min	Max	Min	Max	
LT	02	81.2	81.5	72.3	72.6	13.5	13.5	

Tensile - Room Temperature (SI)

		Ultimate (N/MM2)		Yield (N/MM2)		Elongation (%)		Report
Direction	Tests	Min	Max	Min	Max	Min	Max	
LT	02	562	562	498	501	13.5	13.5	

REF. PART PO# POHBD43778 ITEMS 1, 2, 43
ITEM 1 - BODY, UPPER CUTTER - PART# D5500-1P
ITEM 2 - BODY, LOWER CUTTER - PART# D5501-1P
ITEM 3 - BASE, UPPER CUTTER - PART# D5505-1P

PARTS 39579-1-001939579-1-002 ONLY Q2 JUN 10/19

TN35073-1 E2
Job# 39579
rec'd June 24/19

P-860-155D REVISED: 01 2018

WMP
03

From: TK Materials CA, Ltd.

Cust. WEJAY MACHINE PRODUCTS CO LTD

CstAr

Wgt.: 405.671 LB

Del.: 2406829911

CstOr 35073

Date 06/21/2019





CERTIFIED TEST REPORT
Constellium Rolled Products
Ravenswood, LLC

S
H
I
P
T
O

THYSSENKRUPP CA
2821 LANGSTAFF ROAD
CONCORD ON
L4K 5C6
CA

S
O
L
D
T
O

COPPER & BRASS SALES

PO BOX 5116
SOUTHFIELD MI
48086
US

COPPER&BR		110730252		4075		INCLUSION		Serial:20190201-0110730252		Pg 2of2	
CUSTOMER PURCHASE ORDER NO. & ITEM 5400424185-R01						Constellium ORDER NO. 264541					
ALLOY 7075	CLAD	TEMPER T651	GAUGE 2.03000 in 51.56 mm	WIDTH 60.50000 in 1,537 mm	LENGTH 144.50000 in 3,670 mm	CERTIFICATION "Constellium Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on Constellium Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination." Constellium Rolled Products Ravenswood, LLC 859 Century Road P.O. BOX 68 RAVENSWOOD, WV 26164 USA  Dave Dunbarger - Laboratory Manager					
ITEM ORDERED SPEC PLATE, SAWED MILL FINISH											
CUSTOMER SPECIFICATION AMS QQ-A-250/12A											
PART NUMBER ALFLR00999		B/L NUMBER 112678		DATE SHIPPED 02/01/2019							
WT. SHIPPED 5580.000 LB		NO. OF PIECES 000003		GOVT. CONTRACT NO.							
Chemistry (Actual)											
	SI	FE	CU	MN	MG	CR	ZN	TI	ZR		
Core	0.07	0.19	1.42	0.04	2.47	0.19	5.70	0.03	0.01		
OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER											
All material contained in this lot was cast and manufactured in the USA											
QUALITY TEXTS: Constellium Rolled Products Ravenswood, LLC (Constellium) certifies that all metals and materials supplied are in compliance with European Union Directives 2002/95/EC and 2011/65/EU. Constellium further certifies that a copy of these directives, which provides restrictions on the use of certain hazardous substances (RoHS) in electrical and electronic equipment, have been received and read in their entirety. Constellium understand and agrees, as a supplier that it is responsible for meeting the requirements of the RoHS and RoHS2 directives.											
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. CHEMISTRY BY OES: ARKSPARK CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399 WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557 DUNS Number: 090570149; CAGE Code: 1YW19 Mercury is not a normal contaminant in aluminum alloys and neither mercury nor any of its compounds were utilized in the manufacture of our product. "END OF CERTIFICATION"											
P-850-155D REVISED: 01 2018											

From: TK Materials CA, Ltd.

Cust. WEJAY MACHINE PRODUCTS CO LTD

Del.: 2406829911

CstAr

CstOr 35073

Wgt.: 405.671 LB

Date 06/21/2019

INSPECTION CERTIFICATE (EN 10204/3.1)

Page 1/2

Certificate No. : 2017050391
Customer : THYSSENKRUPP MATERIALS NA
CBS ELKHART 1015 SAINT JEROME STREET, ST.
JOSEPHMISHAWAKA, IN, 46344, US
Purchase Order No. : 5400340943-R01
Mat No. : ALFLR00999
Alloy : 7075
Batch No. : 1750027398
Cast No. : 1-17-0374
Dimensions : 2.000x72.500x144.500 inch
Master standard : ASTM B209-2014, AMS 4045L, AMS-QQ-A-250/12A
Temper : T 651
Quantity : 3
Material Type : Plate

TECHNOLOGICAL PROPERTIES

Mechanical properties:

Spec.: ASTM B209-2014, AMS 4045L, AMS-QQ-A-250/12A

	PI-No.	Spec.No.	Rp1.0	Rp0.2 Ksi	Rm Ksi	A4d %	Z	Rp/Rm
LT Min	-	-	-	67	77	6	-	-
Max	-	-	-	-	-	-	-	-
Act	1	-	-	72.2	83.1	13.8	-	-
Act	1	-	-	72.8	83.7	13.3	-	-

Chemical Composition In %, Remainder Al

Spec.: ASTM B209-2014, AMS 4045L, AMS-QQ-A-250/12A

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Others each	Others total
Min	0.00	0.00	1.20	0.00	2.10	0.18	5.10	0.00	0.00	0.00
Max	0.40	0.50	2.00	0.30	2.50	0.23	8.10	0.20	0.05	0.15
Act	0.034	0.003	1.700	0.003	2.474	0.189	5.729	0.0475	0.0142	0.0354

Other tests

DIMENSIONAL CONTROL: OK
SURFACE CONTROL: OK

MELTED AND MANUFACTURED IN THE PEOPLE'S REPUBLIC OF CHINA.

CERTIFIED THAT THE WHOLE OF THE SUPPLIES DETAILED HEREON HAVE BEEN INSPECTED, TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL RESPECTS WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER. WE CONFIRM, THAT QUALITY SYSTEM OF ALERIS ALUMINUM (ZHENJIANG) CO., LTD. IS IN ACCORDANCE WITH AS 9100C AND ISO 9001 IN THE RELEVANT VALID VERSION AND CERTIFICATED BY AN ACCREDITED 3RD PARTY.

Valid quality management system approvals see: www.aleris.com
QA-CE-02D Effective from April 1st 2017

Page 1/2

From: ThyssenKrupp Materials NA
Cust. THYSSENKRUPP MATERIALS CA LTD Del.: 2405349055
CstAr CstOr 285280
Wgt.: 4,478 LB Date 07/25/2017

Thomas Savary

REF. DART P.O.# POHRO43778 ITEM 1

BODY, UPPER CUTTER PART# D5500-1P S/N 39579-1-004



July 10/19

INSPECTION CERTIFICATE (EN 10204/3.1)

Page 2 / 2

Certificate No. : 2017050391
Customer : THYSSENKRUPP MATERIALS NA
CBS ELKHART 1015 SAINT JEROME STREET, ST.
JOSEPH MISHAWAKA, IN, 46544, US
Purchase Order No. : 5400340943-R01
Mat No. : ALFLR00999
Alloy : 7075
Batch No. : 1750027398
Cast No. : 1-17-0374
Dimensions : 2.000x72.500x144.500 inch
Master standard : ASTM B209-2014, AMS 4045L, AMS-QQ-A-250/12A
Temper : T 651
Quantity : 3
Material Type : Plate

ALERIS ALUMINUM (ZHENJIANG) CO., LTD IS QUALIFIED BY THE MAIN AIRCRAFT OEM:
BOMBARDIER APPROVED SUPPLIER CODE: 132398
BOEING APPROVED SUPPLIER CODE: BE10407245
AIRBUS APPROVED SUPPLIER CODE: 0000305300

MATERIAL CONFORMS TO THE REQUIREMENTS OF EUROPEAN UNION DIRECTIVE 2011/65/EU (ROHS).

Quality Assurance, 2017-May-5
Valid after signature

Zhengchen Wu

Zhengchen Wu

Valid quality management system approvals see: www.aleris.com
QA-CE-02D Effective from April 1st 2017

Page 2 / 2

From: ThyssenKrupp Materials NA
Cust. THYSSENKRUPP MATERIALS CA LTD Del.: 2405349055
CstAr CstOr 285280
Wgt.: 4,478 LB Date 07/25/2017

Tomas Sanchez



Dart Hawkesbury
1270 Aberdeen St Hawkesbury, ON K6A 1K7 Canada
Tel: (613) 632-5200

Purchasing Receipts

PO No	Supplier	Line Item No	Rel No	Terms	Purchased Item	Description	For Part No	Project	Equipment ID	Order Qty	Due Date	Received Quantity	Accounting Job No	Serial No	Status	Receive Date	Price/Unit	Aging Days	Past Due	Total	Supplier Name
PO038143	THYD01- VC	1	1	Net 30	M7075T6S2.000X17.000	7075-T6S Sheet 2.000" X 17.000" (cut to 17" pcs) 8 pcs required				11	11/5/2017	11		0010035	Stock	11/15/2017	\$ 151.77 / ft.	71	80	\$1,719.50	Thyssenkrupp Materials CA Ltd
Total:										11		11								\$1,395.19	

Print: 1/25/2018 3:20 PM Dart Baker Diane

JAN 26 2018



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038143

need to be received

Supplier: THY001-VC
Thyssenkrupp Materials CA Ltd
O/A VPK Metal- c/o T27540
PO Box 4275, Postal "A"
Toronto
ON
M5W 5V8 Canada
Phone: 905 669 9444
Fax: 905 738 9033

PO No: PO038143
PO Date: 10/25/17
Due Date: 11/17/17
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 600 O'Connor Drive
Kingston
ON
K7P 1N3 Canada
Contact: Scott
Phone: 613 384 1662
Fax: 613 384 2997

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	M7075T6S2.000X17.000	-	7075-T6S Sheet 2.000" X 17.000" (cut to 17" pcs) 8 pcs required		Firmed	11/6/17	11.333 ft	0 ft	11 ft	\$151.76515/ft	\$1,719.95

Line Item Note MATERIAL: 7075-T6 OR T651/T6510/T6511/T62 ALUMINUM BAR
AS PER AMS-QQ-A-225/9 OR AMS 4122/4123/4186/4187 OR
PER AMS-QQ-A-200/11 OR QQ-A-250/12 CUT FROM PLATE

mate Wajay

Grand Total: \$1,719.95

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/10/17 1:50 PM dart.lavoie.chantal



thyssenkrupp

thyssenkrupp Materials NA 2821 Longstaff Road, Concord, ON L4K 5C8

DELIVERY NOTE

WEJAY MACHINE PRODUCTS CO LTD
600 O'CONNOR DR
KINGSTON ON K7P 1N3



DATE: 11/17/2017
DOC. NO: 2405558968*
BOL. NO:
ORDER NO: 1403416212
YOUR P/O: 38143
CUSTOMER NO: 10058125
Route: 301-Z1
CONTACT: Stan Ivers
TEL: 905-532-1350 ext 21350
FAX: 905-738-9033 ext 9033
EMAIL: STAN.IVERS@THYSSENKRUP
P.COM

**MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.**

ATTN: CHANTAL/LINDA

**** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
** REFERENCED ON IT ****

Client: DART AEROSPACE LTD 1270 ABERDEEN ST, HAWKESBURY, ON K6A 1K7, CA
Deliveries are carried out for your account and risk acc. to our Gen. Terms & Cond. of Delivery and Payment.

ITEM	DESCRIPTION	NET QTY1 / QTY2	PACKAGE NO.
0010	ALFLR00999		
	7075 Aluminum T651 Non-USI Plate	8 PC	1007998800
	2.00000 (+.030/+ .150) X Width 17.0000 (+.125 X Length 17	494.124 lb	
	+ .125		
	Plate Sawing - Standard		
	Actual Chemistry/Act. Physical		
	Standard Packaging		
	SHIP ON VIM TRANSFER TRUCK		
TAGNUM	QTY	UOM	VEND VENDPO HLOT
PCS			
1013225687	8	PC	COOPER & 0000285280 1750027398 8

SAE AMS 4045|L;SAE AMS-QQ-A-250/12|Rev A;ASTM B209 2014

Total Gross Weight

519.124 lb

All items, not declared as partial delivery, are final quantities.

Delivery Terms: COL gem. Incoterms 2000 Collect shipment MANITOULIN



DELIVERY NOTE

WEJAY MACHINE PRODUCTS CO LTD
600 O'CONNOR DR
KINGSTON ON K7P 1N3

DATE: 11/17/2017
DOC. NO: 2405558968*
BOL. NO:
ORDER NO: 1403416212
YOUR P/O: 38143
CUSTOMER NO: 10058125
Route: 301.21
CONTACT: Stan Ivers
TEL: 905-532-1350 ext 21350
FAX: 905-738-9033 ext 9033
EMAIL: STAN.IVERS@THYSSENKRUP
P.COM

CERTIFICAT DE CONFORMITÉ/CERTIFICATE OF COMPLIANCE

* thyssenkrupp Matériaux NA certifie que le matériel décrit ci-dessus est conforme aux dessins ou spécifications exigés sur le bon de commande et qui sont en vigueur à la date où la commande a été acceptée.

* thyssenKrupp Materials NA certifies that the material described above is in accordance with the drawings or specifications called for on said order that are current on the date order was accepted.

* Nous certifions que le document reproduit ici est une copie conforme du rapport fourni par le fournisseur du matériel où les données résultent de l'analyse faite par un laboratoire qualifié.

David Noordine - Director of Quality Assurance

QUOTE

DATE: 11/10/2017
QUOTE NO: 1202895296
YOUR INQUIRY: 38143 dtd. 11/10/2017
ATTENTION TO: CHANTAL
TEL: 613-632-5200
CUSTOMER NO: 10058125
DEPARTMENT: CAN TOR INS 01
CONTACT: Stan Ivers
TEL: 905-532-1350 ext 21350
FAX: 905-738-9033 ext 9033
EMAIL: STAN.IVERS@THYSSENKRUPP.COM

Thyssenkrupp Materials NA
22355 W 11 Mile Road
Southfield, MI 48033

thyssenkrupp Materials NA



thyssenkrupp

QUOTE

thyssenkrupp Materials NA, 2821 Langstaff Road, Concord, ON L4K 5G6

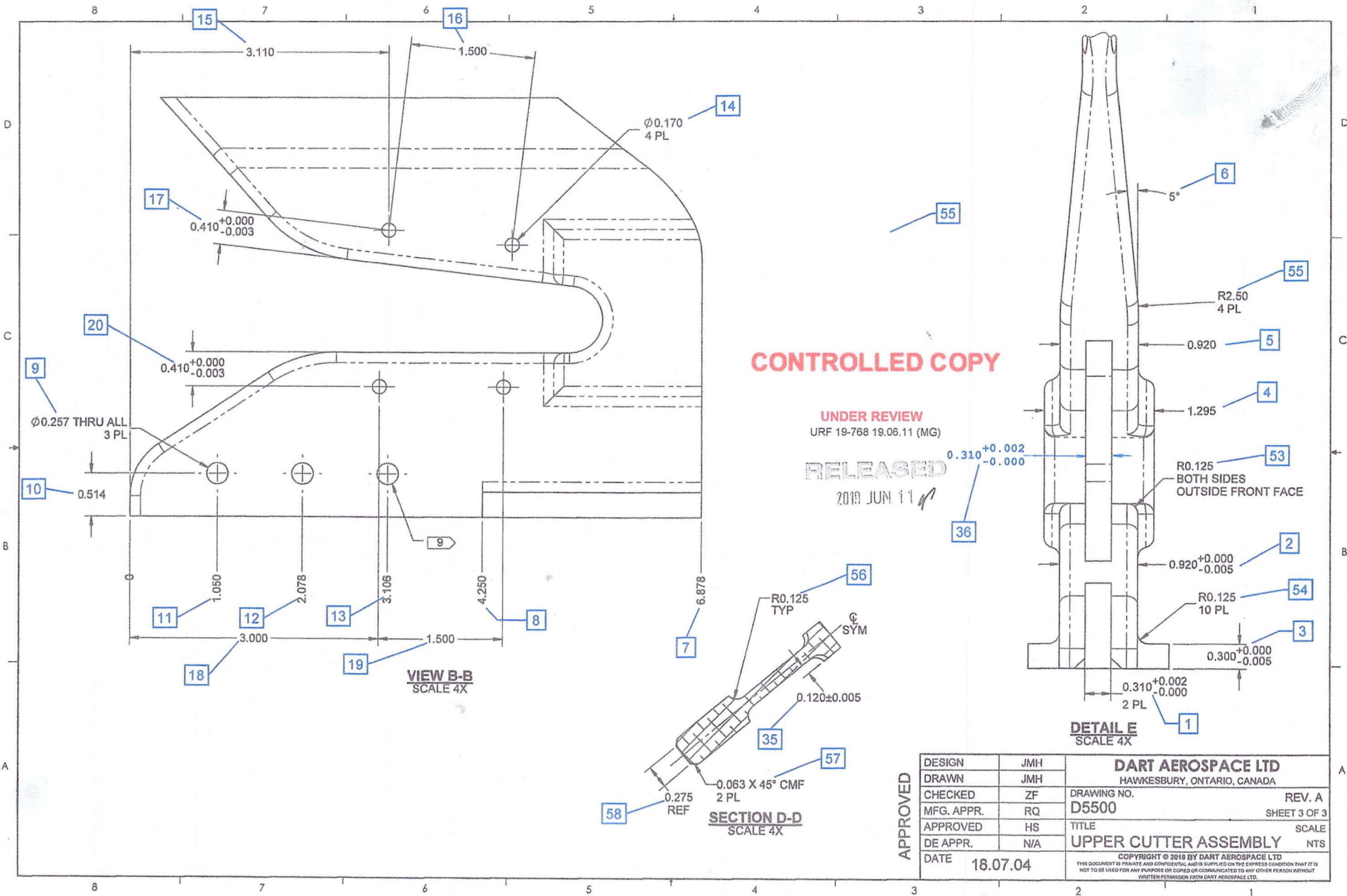
DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7
Canada

DATE:	11/10/2017
QUOTE NO:	1202895296
YOUR INQUIRY:	38143 dtd. 11/10/2017
ATTENTION TO:	CHANTAL
TEL:	613-632-5200

PAGE 2 OF 2

COMPUTER GENERATED OFFER AND VALID WITHOUT SIGNATURE.

Please review the above items for accuracy.
Prices are quoted as price in effect at time of shipment.
Our standard terms and conditions apply should this quote become an order.
For terms and conditions please refer to website at
By accepting the purchase order the terms and conditions are accepted as stated on <http://www.tkmna.com/tkmna/Resources/CustomerService/index.html>
Any obvious damage must be noted on the material delivery documentation at the time of receipt.
Tax exemption status documentation must be forwarded to credit department prior to order approval.
All returned material subject to restock charge





Customer DART Aerospace Customer P.O. POHB043778 item 1
Drawing # D5500 Drawing rev A
Part Number D5500-1P E.C.O. -
Part Name Body Upper Cutter Material Alum. 7075-T651
Serial # 39579-1-001 Inspected by Cliff Smith
Job # 39579 Signature:


WMP
03

ACCEPTED



Overall Result

All Characteristics: 97
Out of tolerance: 0
Over Warning Limit: 0
Not Calculated: 0

Comment: First Article Insp.

Feature	ID	Actual	Nominal	Pos Tol.	Neg Tol.	Deviation	<-- -->
1 3_A2	CartDist	0.3107	0.3100	0.0020	0.0000	0.0007	-
.310 slot faces Parallel	GDT Par	0.0005	0.0000	0.0025		0.0005	-
2 3_B1	CartDist	0.9195	0.9200	0.0000	-0.0050	-0.0005	---
3a 3_B1	Y	0.2979	0.3000	0.0000	-0.0050	-0.0021	-
3b 3_B1	Y	0.2974	0.3000	0.0000	-0.0050	-0.0026	-
4 3_C1	CartDist	1.2950	1.2950	0.0100	-0.0100	0.0000	-
5 3_C1	CartDist	0.9198	0.9200	0.0100	-0.0100	-0.0002	-
6a 3_D1	A2	5.4063	5.0000	0.5000	-0.5000	0.4063	---
6b 3_D1	A1	5.4014	5.0000	0.5000	-0.5000	0.4014	---
7a 3_B4	Z	6.8787	6.8780	0.0100	-0.0100	0.0007	-
7b 3_B4	Z	6.8788	6.8780	0.0100	-0.0100	0.0008	-
8a 3_B6	Z	-4.2500	-4.2500	0.0100	-0.0100	0.0000	-
8b 3_B6	Z	-4.2483	-4.2500	0.0100	-0.0100	0.0017	-
9 side 1_note 10 3_C8(1)	D	0.2431	0.2420	0.0060	-0.0010	0.0011	-
9 side 1_note 10 3_C8(2)	D	0.2428	0.2420	0.0060	-0.0010	0.0008	-
9 side 1_note 10 3_C8(3)	D	0.2429	0.2420	0.0060	-0.0010	0.0009	-
10-13 side 1 B6,B8(1)	GDT Po2d	0.0058	0.0000	0.0200		0.0058	-
	Y	0.5111	0.5140			-0.0029	
	Z	-3.1054	-3.1060			0.0006	
10-13 side 1 B6,B8(2)	GDT Po2d	0.0096	0.0000	0.0200		0.0096	-
	Y	0.5093	0.5140			-0.0047	
	Z	-2.0771	-2.0780			0.0009	
10-13 side 1 B6,B8(3)	GDT Po2d	0.0103	0.0000	0.0200		0.0103	---
	Y	0.5090	0.5140			-0.0050	
	Z	-1.0488	-1.0500			0.0012	
9 side 2_note 10 3_C8(1)	D	0.2425	0.2420	0.0060	-0.0010	0.0005	-
9 side 2_note 10 3_C8(2)	D	0.2424	0.2420	0.0060	-0.0010	0.0004	-
9 side 2_note 10 3_C8(3)	D	0.2423	0.2420	0.0060	-0.0010	0.0003	-
10-13 side 2 B6,B8(1)	GDT Po2d	0.0104	0.0000	0.0200		0.0104	---
	Y	0.5088	0.5140			-0.0052	
	Z	-3.1052	-3.1060			0.0008	
10-13 side 2 B6,B8(2)	GDT Po2d	0.0136	0.0000	0.0200		0.0136	---
	Y	0.5072	0.5140			-0.0068	
	Z	-2.0781	-2.0780			-0.0001	

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
10-13 side 2 B6,B8(3)	GDT Po2d	0.0150	0.0000	0.0200		0.0150	—
	Y	0.5065	0.5140			-0.0075	
	Z	-1.0498	-1.0500			0.0002	
6.7 deg angle ref	A2	6.6712	6.7000	0.2500	-0.2500	-0.0288	—
14a side 1 3_D5	D	0.1698	0.1700	0.0050	-0.0010	-0.0002	—
14a side 2 3_D5	D	0.1700	0.1700	0.0050	-0.0010	0.0000	—
14b side 1 3_D5	D	0.1698	0.1700	0.0050	-0.0010	-0.0002	—
14b side 2 3_D5	D	0.1700	0.1700	0.0050	-0.0010	0.0000	—
14c side 1 3_D5	D	0.1700	0.1700	0.0050	-0.0010	0.0000	—
14c side 2 3_D5	D	0.1700	0.1700	0.0050	-0.0010	0.0000	—
14d side 1 3_D5	D	0.1699	0.1700	0.0050	-0.0010	-0.0001	—
14d side 2 3_D5	D	0.1700	0.1700	0.0050	-0.0010	0.0000	—
15 side 1 3_D7	Z	-3.1088	-3.1100	0.0100	-0.0100	0.0012	—
15 side 2 3_D7	Z	-3.1088	-3.1100	0.0100	-0.0100	0.0012	—
16 side 1 3_D6_R	Dist	1.5001	1.5000	0.0100	-0.0100	0.0001	—
16 side 2 3_D6_R	Dist	1.5003	1.5000	0.0100	-0.0100	0.0003	—
17a side 1 3_D7	CartDist	0.4092	0.4100	0.0000	-0.0030	-0.0008	—
17b side 1 3_D7	CartDist	0.4094	0.4100	0.0000	-0.0030	-0.0006	—
17a side 2 3_D7	CartDist	0.4097	0.4100	0.0000	-0.0030	-0.0003	—
17b side 2 3_D7	CartDist	0.4092	0.4100	0.0000	-0.0030	-0.0008	—
18 side 1 3_B7	Z	-2.9995	-3.0000	0.0100	-0.0100	0.0005	—
18 side 2 3_B7	Z	-3.0007	-3.0000	0.0100	-0.0100	-0.0007	—
19 side 1 3_D6_R	Dist	1.5007	1.5000	0.0100	-0.0100	0.0007	—
19 side 2 3_D6_R	Dist	1.4992	1.5000	0.0100	-0.0100	-0.0008	—
20a side 1 3_C7	CartDist	0.4088	0.4100	0.0000	-0.0030	-0.0012	—
20b side 1 3_C7	CartDist	0.4095	0.4100	0.0000	-0.0030	-0.0005	—
20a side 2 3_C7	CartDist	0.4087	0.4100	0.0000	-0.0030	-0.0013	—
20b side 2 3_C7	CartDist	0.4087	0.4100	0.0000	-0.0030	-0.0013	—
21 2_B5	CartDist	1.6702	1.6700	0.0100	-0.0100	0.0002	—
22 2_C3	A	6.7013	6.7000	0.2500	-0.2500	0.0013	—
23 2_C3	A	32.9954	33.0000	0.5000	-0.5000	-0.0046	—
24 2_C1	R	0.3991	0.3990	0.0100	-0.0100	0.0001	—
25a 2_C2^1	R	1.5054	1.5000	0.0100	-0.0100	0.0054	—
	Angle	0.9936					
25a 2_C2^2	R	1.5054	1.5000	0.0100	-0.0100	0.0054	—
	Angle	10.9949					
25a 2_C2^3	R	1.5050	1.5000	0.0100	-0.0100	0.0050	—
	Angle	20.9927					
25a 2_C2^4	R	1.5045	1.5000	0.0100	-0.0100	0.0045	—
	Angle	31.0021					
25a 2_C2^5	R	1.5040	1.5000	0.0100	-0.0100	0.0040	—
	Angle	40.9957					
25b 2_C2^1	R	1.4943	1.5000	0.0100	-0.0100	-0.0057	—
	Angle	-1.9978					
25b 2_C2^2	R	1.4947	1.5000	0.0100	-0.0100	-0.0053	—
	Angle	5.7592					
25b 2_C2^3	R	1.4953	1.5000	0.0100	-0.0100	-0.0047	—
	Angle	13.4952					

Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
25b 2_C2^4	R	1.4959	1.5000	0.0100	-0.0100	-0.0041	—
	Angle	21.2532					
25b 2_C2^5	R	1.4960	1.5000	0.0100	-0.0100	-0.0040	—
	Angle	29.0001					
26 2_C3	R	0.7504	0.7500	0.0100	-0.0100	0.0004	—
27 2_C5	ResEle	15.4951	15.5000	0.0100	-0.0100	-0.0049	—
28 2_B2	ResEle	15.6307	15.6280	0.0100	-0.0100	0.0027	—
29 2_D3	R	0.2497	0.2500	0.0300	-0.0300	-0.0003	—
30 2_D3	A2	-41.9574	-42.0000	0.5000	-0.5000	0.0426	—
31 2_D2	A2	37.6741	38.0000	0.5000	-0.5000	-0.3259	—
32 2_C1	R	1.9927	2.0000	0.0300	-0.0300	-0.0073	—
33a 2_D5	3d Dist	0.3998	0.4000	0.0100	-0.0100	-0.0002	—
33b 2_D5	3d Dist	0.3992	0.4000	0.0100	-0.0100	-0.0008	—
33c 2_D5	3d Dist	0.3982	0.4000	0.0100	-0.0100	-0.0018	—
33d 2_D5	3d Dist	0.3993	0.4000	0.0100	-0.0100	-0.0007	—
33e 2_D5	3d Dist	0.3996	0.4000	0.0100	-0.0100	-0.0004	—
34a 3_A4	3d Dist	0.1561	0.1600	0.0100	-0.0100	-0.0039	—
34b 3_A4	3d Dist	0.1558	0.1600	0.0100	-0.0100	-0.0042	—
34c 3_A4	3d Dist	0.1556	0.1600	0.0100	-0.0100	-0.0044	—
35a 3_A4_X	Dist	0.1222	0.1200	0.0050	-0.0050	0.0022	—
35b 3_A4_X	Dist	0.1222	0.1200	0.0050	-0.0050	0.0022	—
35a 3_A6_X	Dist	0.1207	0.1200	0.0050	-0.0050	0.0007	—
36 3_B3	CartDist	0.3110	0.3100	0.0020	0.0000	0.0010	—
Knife Slot Sides Parallel	GDT Par	0.0009	0.0000	0.0020		0.0009	—
37 2_C6	CartDist	0.6804	0.6800	0.0100	-0.0100	0.0004	—
38 2_C6	CartDist	0.6805	0.6800	0.0100	-0.0100	0.0005	—
39a 2_C8	R	1.0047	1.0000	0.0300	-0.0300	0.0047	—
39b 2_C8	R	0.9880	1.0000	0.0300	-0.0300	-0.0120	—
40 2_B7	Z	2.0533	2.0480	0.0100	-0.0100	0.0053	—
41 2_C8	Y	2.2907	2.2900	0.0100	-0.0100	0.0007	—
42 2_C7	Z	2.0270	2.0360	0.0100	-0.0100	-0.0090	—
43 2_C8	Y	2.5018	2.5010	0.0100	-0.0100	0.0008	—
44 2_C6	Y	1.0265	1.0280	0.0100	-0.0100	-0.0015	—
45 2_B7	R	2.5557	2.5500	0.0100	-0.0100	0.0057	—



Feature	ID	Actual	Nominal	pos Tol	neg Tol	Diff	<-- -->
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Manually Inspected Details

46	2_B5	0.125 x 45 chamf. 2 pl.					<u>.119-.120x45°</u>
47	2_A2	4.75 dim					<u>4.750 typ.</u>
48	2_A2	R0.125					<u>R.125TYP.</u>
49	2_C1	7.42 dim					<u>7.416-7.421</u>
50	2_C2	0.200 dim					<u>.197-.204</u>
51	2_C3	0.863 dim					<u>.864-.868</u>
52	2_D3	R0.125 3 pl.					<u>R.125TYP.</u>
53	3_B1	R0.125 Both sides outside front face					<u>R.125TYP.</u>
54	3_B1	R0.125 10 pl.					<u>R.125TYP.</u>
55	3_C1	R2.500 4 pl.					<u>R 2.500TYP.</u>
56	3_B4	R0.125 typ.					<u>R.125TYP.</u>
57	3_A4	0.063x 45 chamfer 2 pl.					<u>.063-.068x45°</u>
58	3_A4	.275 ref.					<u>.271-.273</u>
59	2_A8	Deburring per note 5					<u>PASSED</u>
60	2_A8	Identification per note 6					<u>PASSED</u>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: <u>146673</u> Part No. <u>D550-1</u>	DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☒ Quality ☐			
Date : <u>12/07/12</u>	Sequence #: <u>95</u>	QTY Affected : <u>3</u>		MRB (QSI042) <u>INSP 12</u> <u>9</u> <u>12/12</u>	
Description Work Order Deviation <u>Holes outside tolerance.</u> <u>Ø 0.257 on drawing, measuring 0.240", 0.241"</u> <u>Ø 0.170 " " " 0.168"</u>			Disposition <u>Re-work per dwg.</u>		
			Completed By <u>61</u> 9-89		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☒ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☒ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: <u>POMBO4378</u> <u>Line 1.</u>					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044008



Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044008

PO Date: 7/15/19

Due Date: 7/19/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments: ***RUSH***

E-MAILED
2019-07-19

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	196015	646.2910	Deflector : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize, Color Black / Prime As per Dwg 646.2900 Rev. N/C	Firmed	-	7/19/19	16 pcs	0 pcs	16 pcs	\$53.77/pcs	\$860.32
2	196673	D5500-1	Body, Upper Cutter Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/19/19	3 pcs	0 pcs	3 pcs	\$26.52/pcs	\$79.56
3	196674	D5501-1	Body, Lower Cutter, Long Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/19/19	2 pcs	0 pcs	2 pcs	\$26.52/pcs	\$53.04



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044008



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196675	D5505-1	Base, Upper Cutter Outsource process-Anodize per QSI017 4.1.10.1 - Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/19/19	3 pcs	0 pcs	3 pcs	\$24.62/pcs	\$73.86
				X3		JUL 19 2019					DP
							S197502				
5	196676	D5506-3	Base, Lower Cutter, Long Issue P/O to ATG: HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL-P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** Certification of Conformity is required	Firmed	-	7/19/19	2 pcs	0 pcs	2 pcs	\$24.62/pcs	\$49.24
				X2			S197504				DP

Grand Total: \$1,116.02

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 7/19/19 8:32 AM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918248

Date: 18-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
✓ 3 ea	Part: D5500-1 ✓ Body, Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25476 PO: POHB044008 ✓		Rev: A8 Line: 2
✓ 2 ea	Part: D5501-1 ✓ Body, Lower Cutter, Long Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25477 PO: POHB044008 ✓		Rev: A7 Line: 3
✓ 3 ea	Part: D5505-1 ✓ Base, Upper Cutter Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 25478 PO: POHB044008 ✓		Rev: A Line: 4
✓ 2 ea	Part: D5506-3 ✓ Base, Lower Cutter Long Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied),		Rev: A Line: 4

DAS
81
9-89

RECEIVED
JUL 18 2019
DART AEROSPACE LTD.

Made in Canada.

DAS
81
9-89

RECEIVED

JUL 18 2019

DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 918248

Date: 18-Jul-19

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	.0006-.0009" (6 - .9 mils) per drawing. Job: 25479 PO: POHB044008 ✓ Line: 5		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>JUL 18 2019</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			
Made in Canada.			